




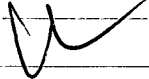




Work Order ID 74256

Page 1

Tuesday, September 27, 2011 1:07:13 PM

Item ID: D4131-5 Accept  Setup Start 
Revision ID: Stop 
Item Name: Side Plate
Start Date: 9/27/2011 Start Qty: 20.00  Cust Item ID:
Required Date: 10/6/2011 Req'd Qty: 20.00  Customer:
Reference:

Approvals: Process Plan:  Date: Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4131	B
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100		0.00
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

Waterjet

FLOW CNC Waterjet

304 .050

Memo

1-Cut as per Dwg

Dwg Rev: Prog Rev: 

2-Deburr if necessary

0.00

131-9-27

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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QC

Quality Control

Memo

0.00

131-9-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74256

Tuesday, September 27, 2011 1:07:13 PM



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Item ID: D4131-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Plate

Start Date: 9/27/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/6/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

5/10/28

724

130

Identify as per dwg & Stock Location: ST/31

0.00



Packaging

Memo

0.00

Packaging

24x

SP 11-09-28

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/28
ME
11-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 1:07:10 PM

Page 1

Work Order ID: 74256



Parent Item: D4131-5



Parent Item Name: Side Plate

Start Date: 9/27/2011

Required Date: 10/6/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

100

sf

288.0050

0.0556

1.170526

1.5



304/316.050 Sheet

B11-9-27

Location

Loc Qty

Loc Code

MAT020

288.005

113062

0.005

119032

288

119032

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

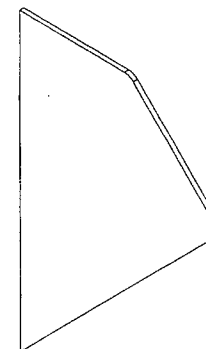
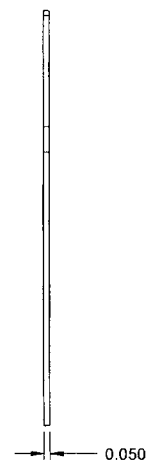
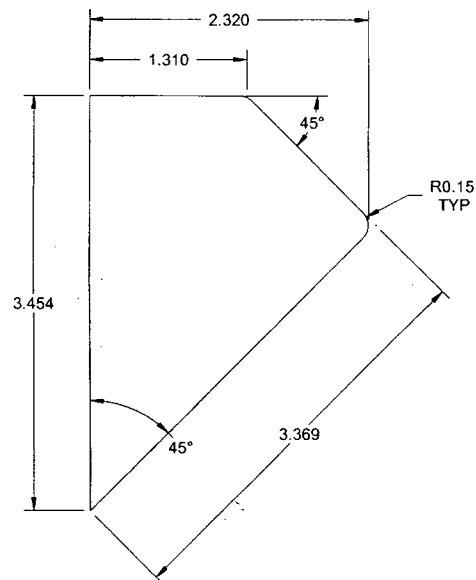
DART AEROSPACE LTD		Work Order:	74256
Description: Side Plate		Part Number:	D4131-5
Inspection Dwg: D4131	Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: RB	Audited by: S	Preliminary Approval:
Date: 11-9-07	Date: 11/05/08	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ	



D4131-5 SIDE PLATE

RELEASED
2011-09-21

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>MB</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>SS</i>	D4131	SHEET 8 OF 10
APPROVED	<i>MB</i>	TITLE	SCALE
DE APPR.	<i>SS</i>	MANIFOLD ASSEMBLY	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	